

Date: Wednesday, 13/05/2009 8:50:28 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : TURNING DETAIL FOR D2896-1
Job Number : 47929	
Estimate Number : 13236	
P.O. Number :	Part Number : DSK080
This Issue : 13/05/2009 S.O. No. :	Drawing Number : DSK080 REV.A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 43480	Material :
Written By :	Due Date : 20/05/2009 Qty: 10 Um: Each
Checked & Approved By : <u>JLD 09.05.13</u>	
Comment : est rev A. 08.03.13 new issue EC Est Rev:B 09-04-09 Now on Doosan Lathe JLM Verified By:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	D6104011	17-4 SS Roundbar 6.50"OD
-----	----------	--------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Billet

Batch: B41969mk 09/05/15

(10)

2.0	DOOSAN LATHE	DOOSAN LATHE
-----	--------------	--------------

**Comment:** DOOSAN LATHE

Turn blank as per Folio FA167

mk 09/05/15

(10)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	----------------------------------------

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINEmk 09/05/15

(10)

4.0	QC8	SECOND CHECK
-----	-----	--------------

**Comment:** SECOND CHECKSA 09/05/19

(10)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------

**Comment:** PACKAGING RESOURCE #1

Identify and Stock in Kanban

Location: CNCSA 09/05/19

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: DSK 080 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 09/05/20
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>47929</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09.05.15	2	0.040 DEEP CHAMFER ON ONE SIDE OF BURE	CP 09.05.15 P QSI 012	Acceptable, Not in stressed Area 	mf 09/05/15	S 09/05/15	CP 09.05.15 P QSI 012	S 09/05/15

NOTE: Date & initial all entries

Date: Wednesday, 13/05/2009 8:50:28 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TURNING DETAIL FOR D2896-1

Job Number: 47929

Part Number: DSK080

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/05/19 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-05-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 47989
Description: Turning Detail for D2896-1		Part Number: DSK080
Inspection Dwg: DSK080	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	3.480	3.485		3.482	3.482	3.482	3.482	3.483
B	3.990	4.010		3.997	3.998	3.996	3.997	3.995
C	3.825	3.845		3.836	3.838	3.838	3.837	3.838
D	0.718	0.738		.726	.732	.730	.727	.728
E	0.090	0.110		.101	.100	.100	.102	.101
F	3.705	3.725		3.715	3.716	3.716	3.717	3.716
G	1.360	1.380		1.370	1.370	1.370	1.368	1.367
H	1.250	1.260		1.260	1.260	1.260	1.260	1.260
I	6.490	6.510		6.498	6.498	6.499	6.499	6.499
J	0.022	0.042		.032	.032	.032	.032	.032
K	0.240	0.260		.250	.250	.250	.250	.250
L	0.107	0.127		.116	.116	.116	.116	.116
M								
N								
O								
P								

Measured by: <i>Amk</i>	Date: 09/05/15
Audited by: <i>SA</i>	Date: 05/05/15
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	<i>[Signature]</i>

DART AEROSPACE LTD		Work Order: 47929
Description: Turning Detail for D2896-1		Part Number: DSK080
Inspection Dwg: DSK080	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	3.480	3.485		3.483	3.481	3.481	3.482	3.482
B	3.990	4.010		3.994	3.995	3.995	3.995	3.990
C	3.825	3.845		3.837	3.838	3.836	3.837	3.835
D	0.718	0.738		.728	.727	.727	.727	.728
E	0.090	0.110		.100	.100	.100	.102	.100
F	3.705	3.725		3.717	3.715	3.715	3.716	3.715
G	1.360	1.380		1.368	1.369	1.367	1.368	1.369
H	1.250	1.260		1.260	1.260	1.260	1.260	1.254
I	6.490	6.510		6.499	6.498	6.498	6.498	6.498
J	0.022	0.042		.032	.032	.032	.032	.032
K	0.240	0.260		.250	.250	.250	.250	.250
L	0.107	0.127		.116	.118	.117	.116	.120
M								
N								
O								
P								

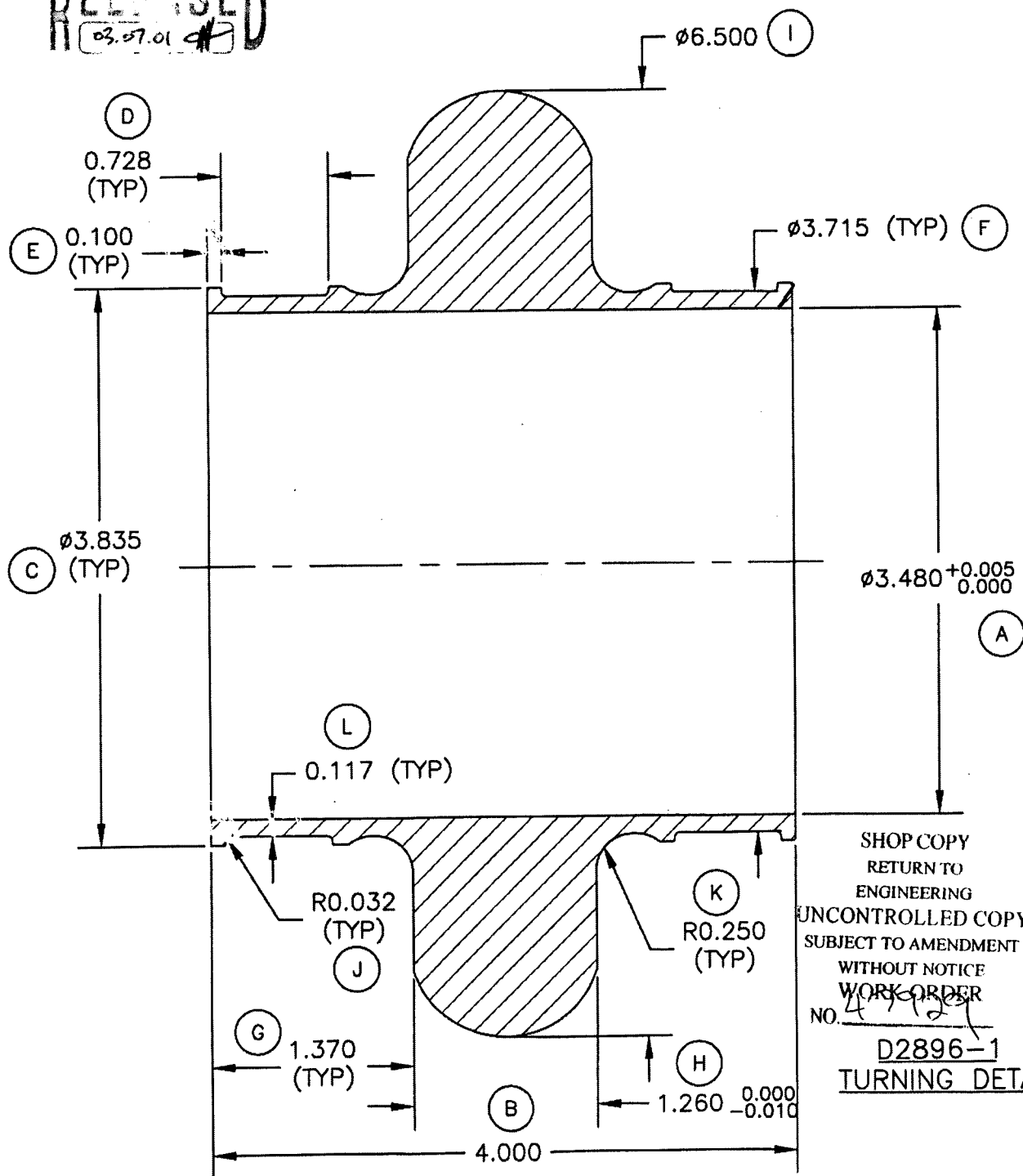
Measured by: <i>gmk</i>	Date: 09/05/19
Audited by: <i>SA</i>	Date: 09/05/19
Prototype Approval: <i>SA</i>	Date:

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	<i>SA</i>



DESIGN [Signature]	DRAWN BY [Signature]	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. DSK 080	REV. A SHEET 1 OF 1
DATE 03.05.20		TITLE TURNING DETAIL FOR D2896-1	SCALE 1:1
A	03.05.20	NEW ISSUE	

RELEASED
03.07.01



Copyright © 2003 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.